

# Work Order ID 84313

May-09-12 1:44:54 PM

*SHIPPED*

**\*84313\***

Page 1

Item ID: D119-647-011

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Bearpaw

Start Date: 09/05/2012 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 23/05/2012 Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Approvals: Process Plan: MCS

Date: 12/05/09 Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3034

Rev A1

100

0.00

**\*100\***

DOCUMENT CONTROL

*5/2/09/29*

*H for MCS 12-6-28*  
*(2)*

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D119-647-011

CHG 002

160

Pick Kit

0.00

**\*160\***

Packaging

Memo

0.00

Packaging

*2x*  
*12-6-28*

170

QC4- 100% Inspect kits for completeness

0.00

**\*170\***

QC

Memo

0.00

Quality Control

*5/2/09/29*

*(2)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

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Revision ID:

Stop \*NS2\*

Item Name: Bearpaw

Start Date: 09/05/2012 Start Qty: 2.00

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Cust Item ID:

Required Date: 23/05/2012 Req'd Qty: 2.00

\*2\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180		0.00							
*180*	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D119-647-011								
	Location: _____								
	PPP Rev: <u>BH</u>								
190	QC21- Final Inspection - Work Order Release	0.00							
*190*									
QC	Memo	0.00							
Quality Control									

20 6/6/09

12/17/13 12/10/12

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# Picklist Print

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Work Order ID: 84313

\*84313\*

Parent Item: D119-647-011

\*D119-647-011\*

Parent Item Name: Bearpaw

Start Date: 09/05/2012

Required Date: 23/05/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 07-02-02 JLM  
IPP Rev:B Update Step 7.0 07-07-28 JLM Verified By:EC  
IPP Rev:C Add MFG Eng Step 2 08-04-13 Verified By:EC  
IPP Rev:D New Manufacturing Method 08-11-17 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3034-1 Bearpaw		Manufactured	No			170	Each	0.0000	2	4			
*D3034-1*									**	89317			
D2182B Rubber Cushion		Manufactured	No			170	f	142.7652	2.75	5.789474			
*D2182B*									**	SP.			

Location	Loc Qty	Loc Code
ST410	142.76517	
63413	1.6	
66063	41.61817	
73932	99.547	

cut to 5.5 per dwg D2182 (D2182B055) {QTY 6}

D2274	Manufactured	No				170	Each	392.0000	12	24			
-------	--------------	----	--	--	--	-----	------	----------	----	----	--	--	--

\*D2274\*  
Radius Block

Location	Loc Qty	Loc Code
ST007	392	
78233	2	
81958	180	
83258	210	

24K

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**\*84313\***

Parent Item: D119-647-011

**\*D119-647-011\***

Parent Item Name: Bearpaw

Start Date: 09/05/2012

Required Date: 23/05/2012

Start Qty: 2.00

Required Qty: 2.00

D2529

Manufactured No

170

Each

275.0000

12

24

\*\*

**\*D2529\***

Washer

## Location

## Loc Qty

## Loc Code

ST010

275

79485

18

81873

257

Manufactured No

170

Each

48.0000

6

12

\*\*

D2947

**\*D2947\***

Clamp

## Location

## Loc Qty

## Loc Code

ST456

48

73415

8

77557

40

Purchased No

170

Each

623.0000

12

24

\*\*

AN4-15A

**\*AN4-15A\***

Bolt

## Location

## Loc Qty

## Loc Code

358

100

121652

100

GA

100

120449

100

ST358

423

118706

3

119449

1

119749

3

120422

116

121444

100

121541

200

24X

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Shop Packet Print

Page 2

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item: D119-647-011

**\*D119-647-011\***

Parent Item Name: Bearpaw

Start Date: 09/05/2012

Required Date: 23/05/2012

Start Qty: 2.00

Required Qty: 2.00

AN960JD416

NAS1149D0463J

Purchased

No

170

Each

30.0000

12

24

**\*AN960JD416\***

Washer

\*\*

m/12/19/12 SP

Location

Loc Qty

Loc Code

ST351

30

116289

10

119097

20

MS21042L4

Purchased

No

170

Each

5,208.000

12

24

**\*MS21042L4\***

Nut

\*\*

SP 12-6-28

Location

Loc Qty

Loc Code

ST300

5208

119075

241

121011

1687

121444

2980

121652

300

24x

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

A1 F03 01.06  $\phi 0.93$  WAS  $\phi 0.75$

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

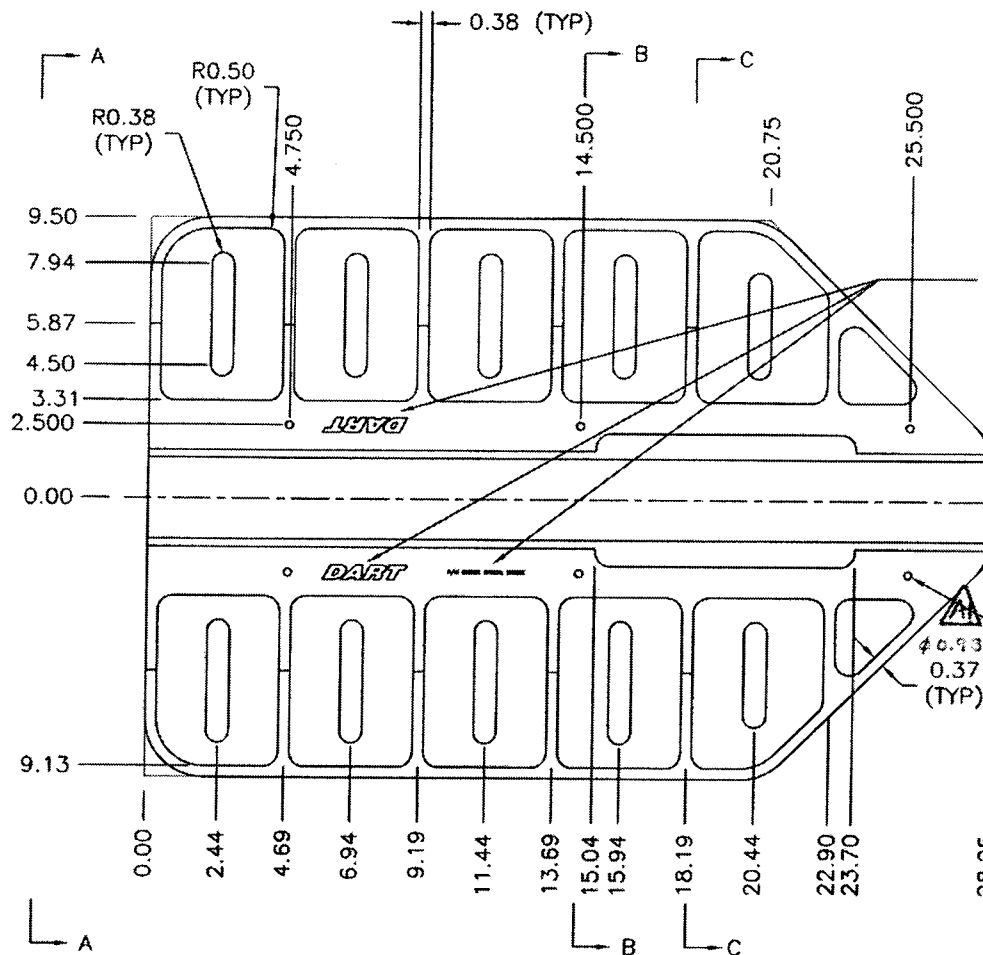
WITHOUT NOTICE

WORK ORDER

NO. 84313 MWS

12/05/09

**DART**



ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)

R2.00 (TYP)

2.00

$\phi 0.260$  (TYP 6 PLACES)

$\phi 0.75$  C'BORE x 0.30 DEEP FROM BOTTOM (LEAVE 0.650 MIN.)

$\phi 0.93$   
0.37 (TYP)

0.950 (REF)

**RELEASED**  
01.06.26

D3034-1

BEARPAW IS SYMMETRIC ABOUT CENTERLINE (EXCEPT FOR ENGRAVING)

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689

1.00 THICK (MACHINE TO 0.950)

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DESIGN	DRAWN BY	DART Aerospace USA, Inc.
124	CP	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
124	124	D3034
DATE	TITLE	REV. A
01.06.21	BEARPAW	SHEET 1 OF 2
A	01.06.21	NEW ISSUE
		SCALE 1:6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

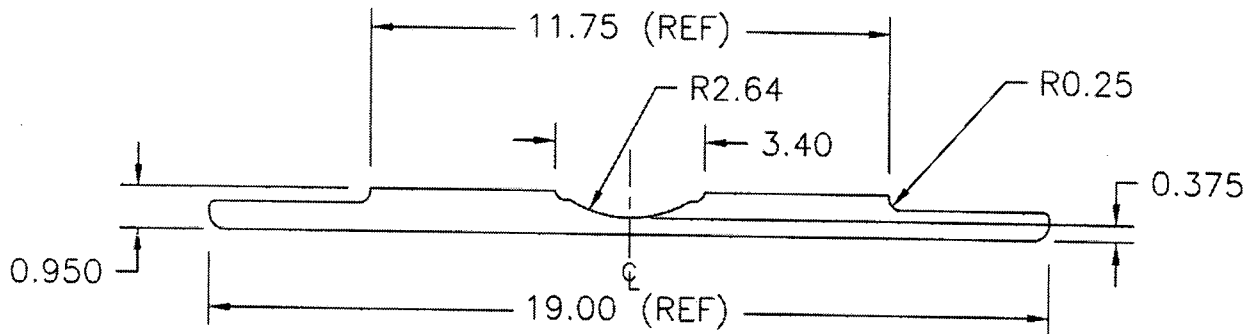
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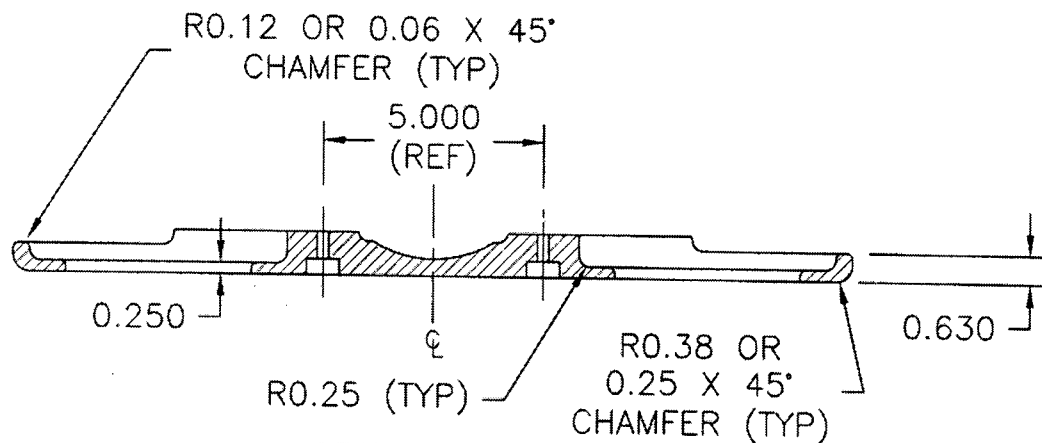
84313



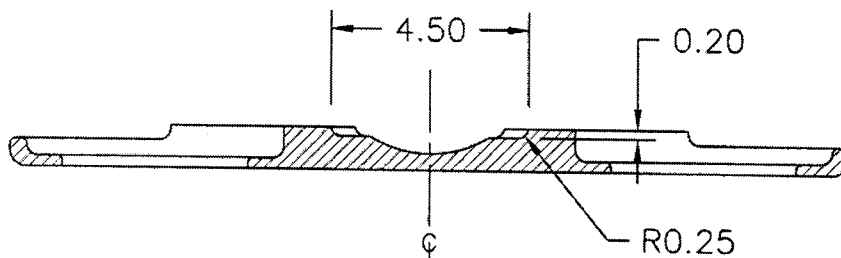
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3034	REV. A
DATE 01.06.21		TITLE BEARPAW	SHEET 2 OF 2
			SCALE 1:4



VIEW A-A  
(ROTATED 90° CCW)



SECTION B-B  
(ROTATED 90° CCW)



SECTION C-C  
(ROTATED 90° CCW)

RELEASED  
01.06.26

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**NOTE:** Date & initial all entries

5. Additional AN960JD416 washers may be installed under the nuts to ensure 1.5-4 threads in safety on the bolts. Although not generally necessary, it is also acceptable to replace the AN4-15A bolts with longer or shorter AN4 bolts, if required.
6. Lower the aircraft

### 32.2 BEARPAW REMOVAL

1. Jack up the aircraft.
2. Loosen the clamp bolts and remove the bearpaws and clamps. Ensure the skidtubes are serviceable.
3. Lower the aircraft.

### 32.3 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D119-647-011 Bearpaw Installation on model A119 aircraft	15.4 lb 7.00 kg	0.0 in 0.0 m	0.0 lb-kp 0.0 m-kp	173.2 in 4.40 m	2667 in-lb 30.8 m-kp

### 32.4 PARTS LIST

Qty	Part Number	Description
X	D119-647-011	BEARPAW INSTALLATION
6	D2182B055	RUBBER CUSHION
12	D2274	RADIUS BLOCK
2	D3034-1	BEARPAW
12	D2529	WASHER
6	D2947	CLAMP
12	AN4-15A	BOLT
12	AN960JD416	WASHERS
12	MS21042L4	NUT (OR MS21042-4)